

Work Order ID 55355

January 13, 2010 2:45:49 PM

Page 1

Item ID: D3947-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Panel, Upper LH Post

Start Date: 1/13/10 Start Qty: 1.00

Cust Item ID:

Required Date: 1/19/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *PL*Date: *10-1-13*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3947

A

100

0.00



HAND FINISHING THERMOFORMING

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut Blanks to fit frame size

PL 10/01/13 *(X)*

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-up

2-Pre-heat tool

3-Thermoform as per Dwg. D36476-1 and Folio FTA 044 using tool DT9483

Dwg. Rev. *A*Folio Rev. *A**PL 10/01/13* *(X)*

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect for proper formation of each part

Dr. 10/01/13 (X)

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B 10/01/14 (X)

140

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3946-1

Dr. 10/01/14 (X)

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Setup Start



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Stop



Item Name: Panel, Upper LH Post

Start Date: 1/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Check dimensions to ensure conformity to drawing tolerances.

10/10/14 (X)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ Siobhán

(X)

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

10-1-18 R SP

Work Order ID 55355

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Page 4

Item ID: D3947-1

Accept

Setup Start

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Stop

Item Name: Panel, Upper LH Post

Start Date: 1/13/10 Start Qty: 1.00

Required Date: 1/19/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: Process Plan: Date:

Tooling: Date:

Stop

QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/1978
NF
10-1-18

Picklist Print

January 13, 2010 2:45:53 PM

Page 1

Work Order ID: 55355

Parent Item: D3947-1

Parent Item Name: Panel, Upper LH Post

Comments: IPP RevA: New issue DD verified by:EC

Start Date: 1/13/10

Required Date: 1/19/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	749.8927	3.4795			



GE PLASTICS LEXAN SHEET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	749.8926526	
107574	16.62	
111973	190.526053	
112176	542.7466	

3,305.4 sq ft Wk 10/01/13 (x1)

DART AEROSPACE LTD		Work Order: 55355
Description: Panel, Upper LH		Part Number: D3947-1
Inspection Dwg: D3947	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: ME

Date: 10/01/14

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.0	Min	10.0	✓			
0.2	Min	0.24	✓			
0.5	Min	0.57	✓			
1.8	Min	1.8	✓			
3.1	REF	3.125	✓			
26.6	REF	26.7	✓			
0.050	Min	0.064	✓			
0.070	Min	0.071	✓			

Measured by: ME

Date: 10/01/14

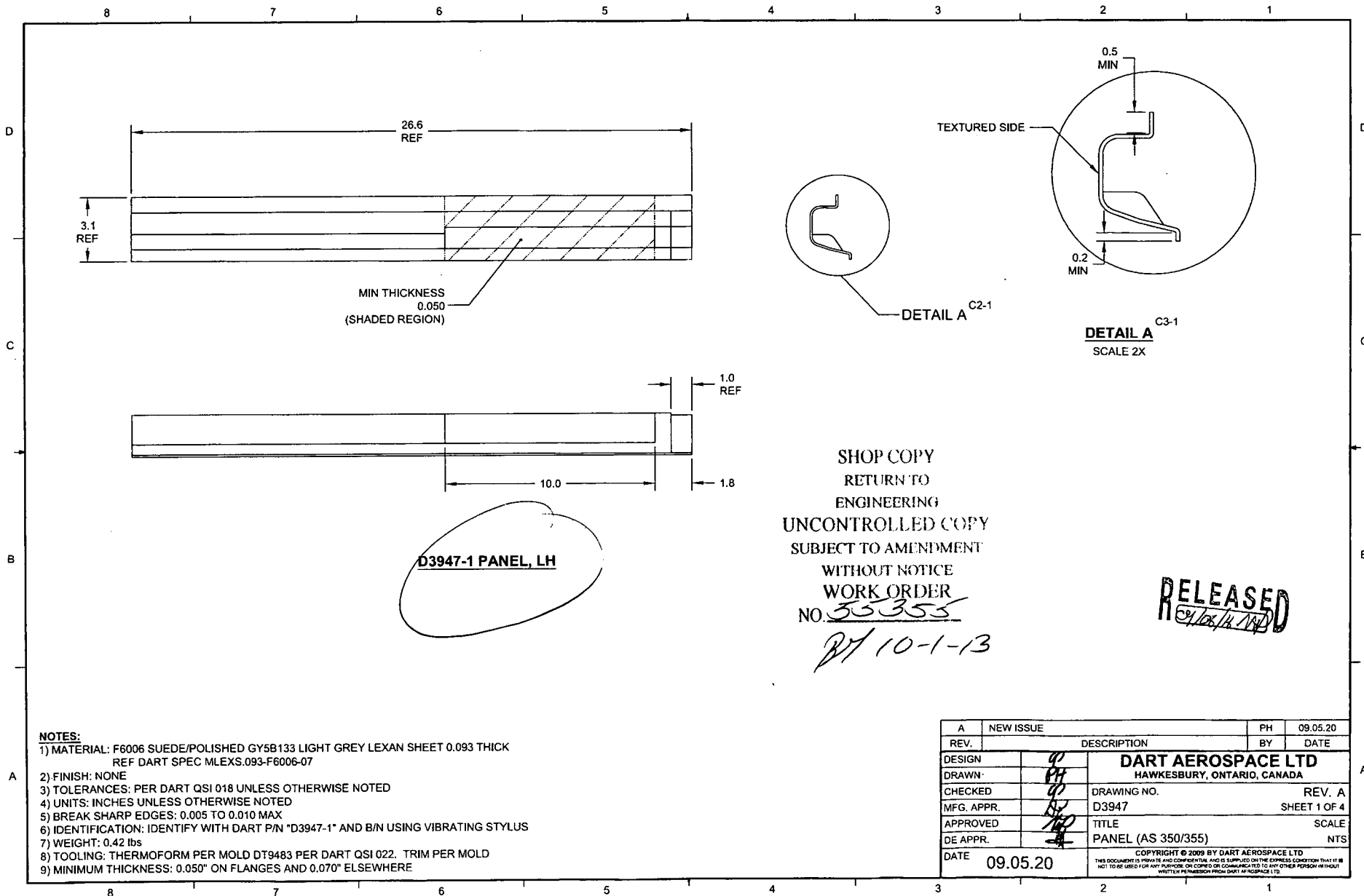
Audited by: BB

Date: 10/01/14

Prototype Approval: N/A

Date: N/A

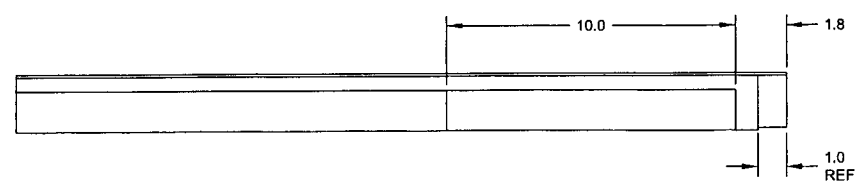
Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>[Signature]</u>



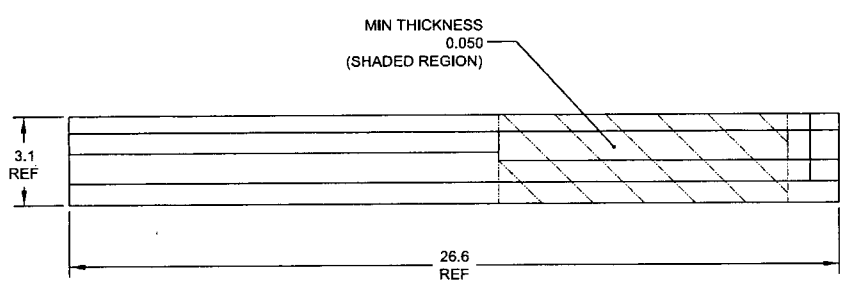
RELEASED
04/08/14/14

8 7 6 5 4 3 2 1

D

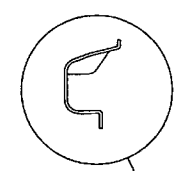


C

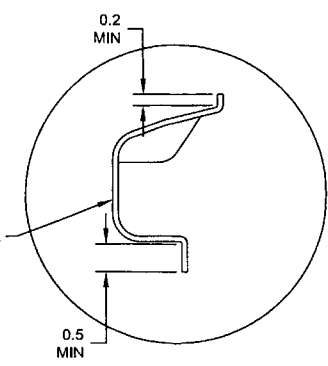


D3947-2 PANEL, RH

B



DETAIL B C2-2



DETAIL B B3-2
SCALE 2X

D

C

B

RELEASED
09/05/20

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-2" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.42 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9483 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.070" ELSEWHERE

A

DESIGN	4110 35355	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	82	D3947	SHEET 2 OF 4
APPROVED	149	TITLE	SCALE
DE APPR.	149	PANEL (AS 350/355)	NTS
DATE	09.05.20	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

